

Work Order ID 121727

July-02-14 9:55:16 AM

121727

Page 1

Item ID: D350-822-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/02/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-07-02

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-822	C								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-822-011								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

MLS 15-01-26

DAS
46
9-89

APR 20 2015

(1x)

CHC003
001

DAS
27
9-89

15/1/26

DAS
28
10-89



DAS
46

APR 20 2015

(1x)

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 121727

July-02-14 9:55:16 AM

121727

Page 2

Item ID: D350-822-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/02/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125

Consignment Stock

0.00

125

Outsourc10

Consignment stock

Memo

0.00

Issue PO to GL account 50000-25 to LEAVE W/O OPEN UNTIL SOLD

Pull for amount sold on sales order S/O 120004
according to sales price see Warran for amount.

PO 28178

PO can be received immediately and given to finance in order to close work order.

121544.20

130

Packaging

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-822-011

Location: Sold

(12) DAS 46 9-89 15/04/20

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MW 15-04-20

MF
15-4-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Transport									
Unapproved									

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Picklist Print

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Page 1

Work Order ID: 121727

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Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP
REV:B 14.06.18 AS PER IIN REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
QB21304 *QB21304* PUREair Panel Assembly	DAS Serial # 46 PAS-S153 9-89	Purchased	No				Each	13.0000	**	1 129914			DAS 86 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MEZZ2			13						
				m129631			9						
				m129632			4						
QB21310 *QB21310* Transition Duct Assembly	DAS 46 9-89	Purchased	No				Each	13.0000	**	1 129914			DAS 86 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MEZZ2			13						
				m129631			9						
				m129632			4						
QB21308 *QB21308* Fod Screen Assembly	DAS 46 9-89	Purchased	No				Each	13.0000	**	1 129914			DAS 86 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MEZZ2			13						
				m129631			9						
				m129632			4						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

July-02-14 9:55:20 AM

Page 2

Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

BS4320-A5

DAS

Purchased

No

Each

714.0000

51

RS4320-A5

46

Washer

**

129914

DAS

66

9-89

Location

Loc Qty

Loc Code

MEZ002

714

M129631

510

M129632

204

LN9038-05-14

Purchased

No

Each

0.0000

51

I N9038-05-14

46

Bolt

**

16116 129914

DAS

66

9-89

QD3108-BJ-05-SC

Purchased

No

Each

70.0000

5

QD3108-BJ-05-SC

DAS

Anchor nut

**

129914

DAS

66

9-89

Location

Loc Qty

Loc Code

M129632

20

M129632

20

MEZ002

50

M129631

50

QD3387B3-03

Purchased

No

Each

140.0000

10

QD3387B3-03

DAS

Rivet

**

129914

DAS

66

9-89

Location

Loc Qty

Loc Code

M129632

40

M129632

40

MEZ002

100

M129631

100

July-02-14 9:55:20 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

July-02-14 9:55:20 AM

Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

650.0401

DAS

Purchased

No

Each

14.0000

1

650 0401

DAS
46

PUREair Fairing Assembly

**

DAS

27

JAN 26 2015

Location

Loc Qty

Loc Code

CA

1

m127899

1

ST

8

m129351

3

m129465

5

ST252A

5

m129173

5

B130067

D4925-041

DAS

Manufactured

No

Each

0.0000

1

D4925-041

DAS
46

Mounting Plate Assembly

**

DAS

27

JAN 26 2015

D4931-1

Manufactured

No

Each

8.0000

1

D4931-1

DAS

Engine Fitting (for acft models B2 & previous)

**

DAS

27

JAN 26 2015

Location

Loc Qty

Loc Code

ST127

2

113897

2

st128

6

119857

6

B120906

D4931-3

Manufactured

No

Each

26.0000

1

D4931-3

DAS

Engine Fitting (for B3 models)

**

DAS

27

JAN 26 2015

Location

Loc Qty

Loc Code

ST127

26

113898

1

119858

5

120907

20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

July-02-14 9:55:20 AM

Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

D4931-5
D4931-5
 Engine Fitting (for B3e models)

DAS
46
 9-89

Manufactured No

Each 28.0000 1

**

DAS
 27

JAN 26 2015

Location

Loc Qty

Loc Code

ST127

28

113899

1

119859

5

120908

22

Each

32.0000

6

**

DAS
 27

JAN 26 2015

D4935-1
D4935-1
 Mounting Bracket

DAS
46
 9-89

Manufactured No

Location

Loc Qty

Loc Code

prelim

26

119860

26

ST133

6

113900

6

Each

13.0000

1

**

DAS
 27

JAN 26 2015

D4943-1
D4943-1
 Flex Hose

DAS
46

Manufactured No

Location

Loc Qty

Loc Code

ST163

13

119749

5

119750

8

Each

16.0000

1

**

DAS
 27

JAN 26 2015

D4961-041
D4961-041
 Tube Assembly

DAS
46
 9-89

Manufactured No

Location

Loc Qty

Loc Code

st128

16

113902

1

119861

5

120910

10

1

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

July-02-14 9:55:20 AM

Page 5

Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

D5079-1
D5079-1
Placard, EAPS

DAS
46
9-89

Purchased No

Each 30.0000 2

**

DAS
27
JAN 26 2015

Location

Loc Qty

Loc Code

ST130

30

121243

30

Each 0.0000

**

1

DAS
27
JAN 26 2015

D5090-041
D5090-041
Duct Assembly

DAS
46
9-89

Manufactured No

Each 0.0000

**

1

DAS
27
JAN 26 2015

D5105-1
D5105-1
Handle

DAS
46
9-89

Manufactured No

Each 44.0000

**

2

DAS
27
JAN 26 2015

Location

Loc Qty

Loc Code

ST132

44

121244

44

Each 0.0000

**

1

DAS
27
JAN 26 2015

D5110-1
D5110-1
Swivel Nut Fitting

DAS
46
9-89

Manufactured No

Each 0.0000

**

1

DAS
27
JAN 26 2015

8411999090
8411999090
Gasket

Purchased No

Each 0.0000

**

1

DAS
27
JAN 26 2015

9752018044
9752018044
Gasket (for B3 models)

DAS
46
9-89

Purchased No

Each 24.0000

**

1

DAS
27
JAN 26 2015

Location

Loc Qty

Loc Code

ST390

24

m128323

9

m129550

15

1

July-02-14 9:55:20 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 6

Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

9945000120

Purchased

No

Each

24.0000

1

DAS
27
9-89

9945000120

DAS
46
9-89

Gasket (for B3e models)

Location

Loc Qty

Loc Code

ST390

24

m128322

9

m129550

15

Each

100.0000

2

JAN 26 2015

23350CA050

Purchased

No

Each

100.0000

2

DAS
27
9-89

23350CA050

DAS
46
9-89

WASHER

Location

Loc Qty

Loc Code

ST567

100

m129609

100

Each

78.0000

1

DAS
27
9-89

AN3-24A

Purchased

No

Each

78.0000

1

JAN 26 2015

AN3-24A

DAS
46
9-89

Bolt

Location

Loc Qty

Loc Code

ST348

50

m129591

50

ST352

28

m128062

4

m128356

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

AN3-3A

Purchased

No

Each

657.0000

24

DAS

27

9-89

JAN 26 2015

AN3-3A

DAS

46

Bolt

Location

Loc Qty

Loc Code

ST350

657

m126249

1

m127815

4

m128429

92

m128973

200

m129591

360

24

DAS

27

9-89

JAN 26 2015

AN821-12J

Purchased

No

Each

18.0000

1

DAS

27

9-89

JAN 26 2015

AN821-12J

DAS

46

Elbow (or AN821-12K or 12S)

9-89

Location

Loc Qty

Loc Code

Mezz

4

280

4

ST324

14

m128356

4

m129566

10

1

DAS

27

9-89

JAN 26 2015

MS20470AD3-4

Purchased

No

Each

7,597.000

18

DAS

27

9-89

JAN 26 2015

MS20470AD3-4

DAS

46

Rivet, Universal Head

9-89

Location

Loc Qty

Loc Code

ST312

7597

111477

7597

18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 8

Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Purchased

No

Each

3,612.000

6

MS20600-AD4W4

DAS

46

Rivets

9-89

Location

Loc Qty

Loc Code

ST310

3612

125577

215

M128429

397

M128899

3000

Each

5,481.000

24

MS21042L3

Purchased

No

MS21042L3

DAS

46

Nut

9-89

Location

Loc Qty

Loc Code

ST307

5481

123900

955

M126333

34

M127410

13

M127831

41

M128401

48

M128754

4390

Each

0.0000

1

MS21919WCH12

Purchased

No

MS21919WCH12

DAS

46

Clamp

MS35207-279

Purchased

No

MS35207-279

DAS

46

Screw

9-89

Location

Loc Qty

Loc Code

ST281

632

m128356

232

m129519

100

m129582

300

DAS
27
9-89
JAN 26 2015

DAS
27
9-89
JAN 26 2015

DAS
27
9-89
JAN 26 2015

DAS
27
9-89
JAN 26 2015

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Page 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

July-02-14 9:55:20 AM

Page 9

Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

MS35207-280

Purchased

No

Each

148.0000

2

MS35207-280

46

Screw

9-8

DAS

27

JAN 28 2015

Location

Loc Qty

Loc Code

ST282

148

m128356

98

m129591

50

NAS1149C0432R

Purchased

No

Each

2,968.000

20

NAS1149C0432R

DAS

46

WASHER

9-89

DAS

27

JAN 26 2015

Location

Loc Qty

Loc Code

ST278

2968

119124

6

121255

2

122441

31

m125807

1389

m126221

1540

NAS1149D0332J

Purchased

No

Each

3,142.000

51

NAS1149D0332J

DAS

46

Washer

9-89

DAS

27

JAN 26 2015

Location

Loc Qty

Loc Code

ST276

3142

m128606

217

m128612

2725

m129624

200

NAS43DD3-131

Purchased

No

Each

28.0000

1

NAS43DD3-131

DAS

46

Spacer

9-89

DAS

27

JAN 26 2015

Location

Loc Qty

Loc Code

ST271

28

m128057

8

m129519

20

July-02-14 9:55:20 AM

Shop Packet Print

Page 9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 10

July-02-14 9:55:20 AM

Work Order ID: 121727

121727

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for the AS350/EC130

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 1.00

Required Qty: 1.00

AN929-12J

Purchased

No

Each

15.0000

1

AN929-12J

DAS

46

Cap

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

CA

15

m129591

15

JAN 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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APR 20 2015 DAS
46
 9-89

5.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D350-822-011	PA100 PUREAIR SYSTEM
1	QB21304	PUREAIR PANEL ASSY
1	QB21310	TRANSITION DUCT ASSY
1	QB21308	FOD SCREEN ASSY
51	BS4320-A5	WASHER
51	LN9038-05-14	BOLT
5	QD3108-BJ-05-SC	ANCHOR NUT
10	QD3387B3-03	RIVET
1	650.0401	PUREAIR FAIRING ASSY
1	D4925-041	MOUNTING PLATE ASSY
1	D4931-1	ENGINE FITTING (FOR ACFT MODELS B2 AND PREVIOUS)
1	D4931-3	ENGINE FITTING (FOR B3 MODELS)
1	D4931-5	ENGINE FITTING (FOR B3e MODELS)
6	D4935-1	MOUNTING BRACKET
1	D4943-1	FLEX HOSE
1	D4961-041	TUBE ASSEMBLY
2	D5079-1	PLACARD
1	D5090-041	DUCT ASSEMBLY
2	D5105-1	HANDLE
1	D5110-1	SWIVEL NUT FITTING
1	8411999090	GASKET (FOR B2 MODELS AND PREVIOUS)
1	9752018044	GASKET (FOR B3 MODELS)
1	9945000120	GASKET (FOR B3e MODELS)
2	23350CA050	LOCKING TAB
1	AN3-24A	BOLT
24	AN3-3A	BOLT
1	AN821-12J	ELBOW (OR AN821-12K OR AN821-12S)
18	MS20470AD3-4	RIVET
6	MS20600AD4W4	RIVET
24	MS21042L3	NUTS
1	MS21919WHG12	CLAMP
18	MS35207-279	SCREW
2	MS35207-280	SCREW
20	NAS1149C0432R	WASHER
51	NAS1149D0332J	WASHER
1	NAS43DD3-131	SPACER
1	AN929-12J	CAP

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Revision: **C**
 Date: 14.06.06

Work Order ID 121727

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July-02-14 9:55:16 AM

Item ID: D350-822-011 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: PA100 PUREair System for the AS350/EC130
 Start Date: 7/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/02/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 4-07-02 Tooling: Date:
 QC: Date: SPC (Y/N): Date: Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-822	C								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-822-011								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
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see attachment

MLS 15-01-26

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8-09

15/1/26

Change Record

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Part Number: D350-822-011

Description: PA100 PUREAIR SYSTEM

[illegible]